

# Work Order ID 85357

**\*85357\***

Page 1

June-06-12 4:22:19 PM

Item ID: D4020-11

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: End Mesh, Basket

Start Date: 06/06/2012 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 12/06/2012 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/07 Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>					<b>(6)</b>			
D4020	A								
100		0.00							
<b>*100*</b>	FLOW WATER JET								
Waterjet	<b>Memo</b>	0.00							12-6-7
FLOW CNC Waterjet	1-Cut as per Dwg D4020 Dwg Rev: <u>h</u> Prog Rev: <u>h</u> 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
<b>*110*</b>									
QC	<b>Memo</b>	0.00							12-6-7
Quality Control	***CUT OUTS WILL BE CUT BY WELDERS WHEN INSTALL ON BASKET***								
120	QC8- Inspect parts - second check	0.00							
<b>*120*</b>									
QC	<b>Memo</b>	0.00							12.06.07
Quality Control	***CUT OUTS WILL BE CUT BY WELDERS WHEN INSTALL ON BASKET***								

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\*6\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Identify as per dwg & Stock Location: **WA**

0.00

\*130\*

Packaging

Memo

0.00

Packaging

**PL 12-06-07**

140

QC21- Final Inspection - Work Order Release

0.00

\*140\*

QC

Memo

0.00

Quality Control

**12/6/11**

**ME**

**12-06-08**

# Picklist Print

June-06-12 4:22:22 PM

Page 1

Work Order ID: 85357

**\*85357\***

Parent Item: D4020-11

**\*D4020-11\***

Parent Item Name: End Mesh, Basket

Start Date: 06/06/2012

Required Date: 12/06/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevA: new issue DD 09.11.26 verified by:EC IPP Rev:B as  
per dwg revA 10.03.15 verified by:EC IPP Rev:C 10.06.14 remove  
cut out from dxf, will be made when install on basket DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304EX0.75-16F		Purchased		No		100	sf	634.1584	2.694	17.01474	20,		

**\*M304FX0 75-16F\***

Expanded Metal Flat SS

\*\*

13-2-6-7

Location	Loc Qty	Loc Code
WA	40.4354	
121471	6.7668	
121738	33.6686	
WA035	593.7229637	
117197	102.9036	
120917	101.57273	
121521	0.00013372	
121849	389.2465	

121471 6.7668  
121738 33.6686  
13-2-6-7

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	05357
<b>Description:</b> End Mesh, Basket		<b>Part Number:</b>	D4020-11
<b>Inspection Dwg:</b> D4020	<b>Rev:</b> A	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
24.34	+/-0.030	24.31	✓		T (BU)	
2.88	+/-0.030	2.89	✓		T	
17.31	+/-0.030	17.31	✓		T	
15.50	+/-0.030	15.50	✓		T	
20.18	+/-0.030	20.18	✓		T	

<b>Measured by:</b> B	<b>Audited by:</b> [Signature]	<b>Preliminary Approval:</b>	N/A
<b>Date:</b> 12-6-7	<b>Date:</b> 12-06-07	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	10.04.01	New Issue	KJ	[Signature]
B	10.08.03	Dimensions updated	KJ	[Signature]

D

C

B

A

D

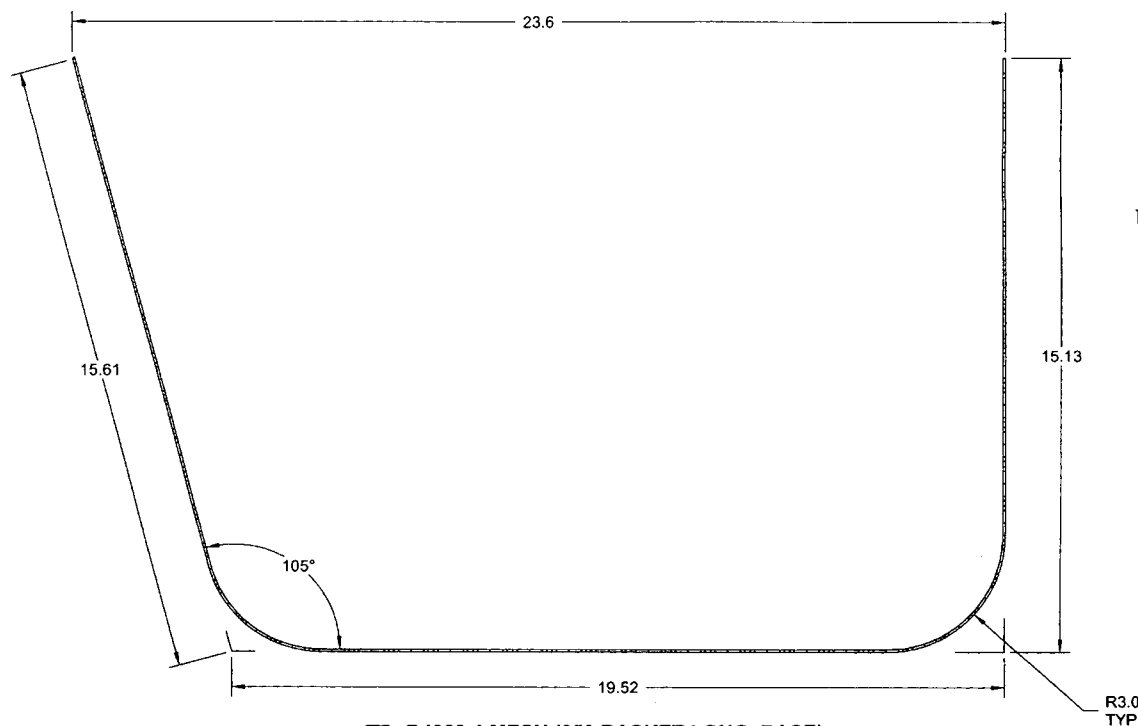
C

B

A

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 85357 MLJ

12/06/07



9 D4020-1 MESH (350 BASKET LONG, BASE)  
(SEE D4020-1F FOR LENGTH)

9 D4020-3 (350 BASKET SHORT, BASE)  
(SEE D4020-3F FOR LENGTH)

R3.0  
TYP

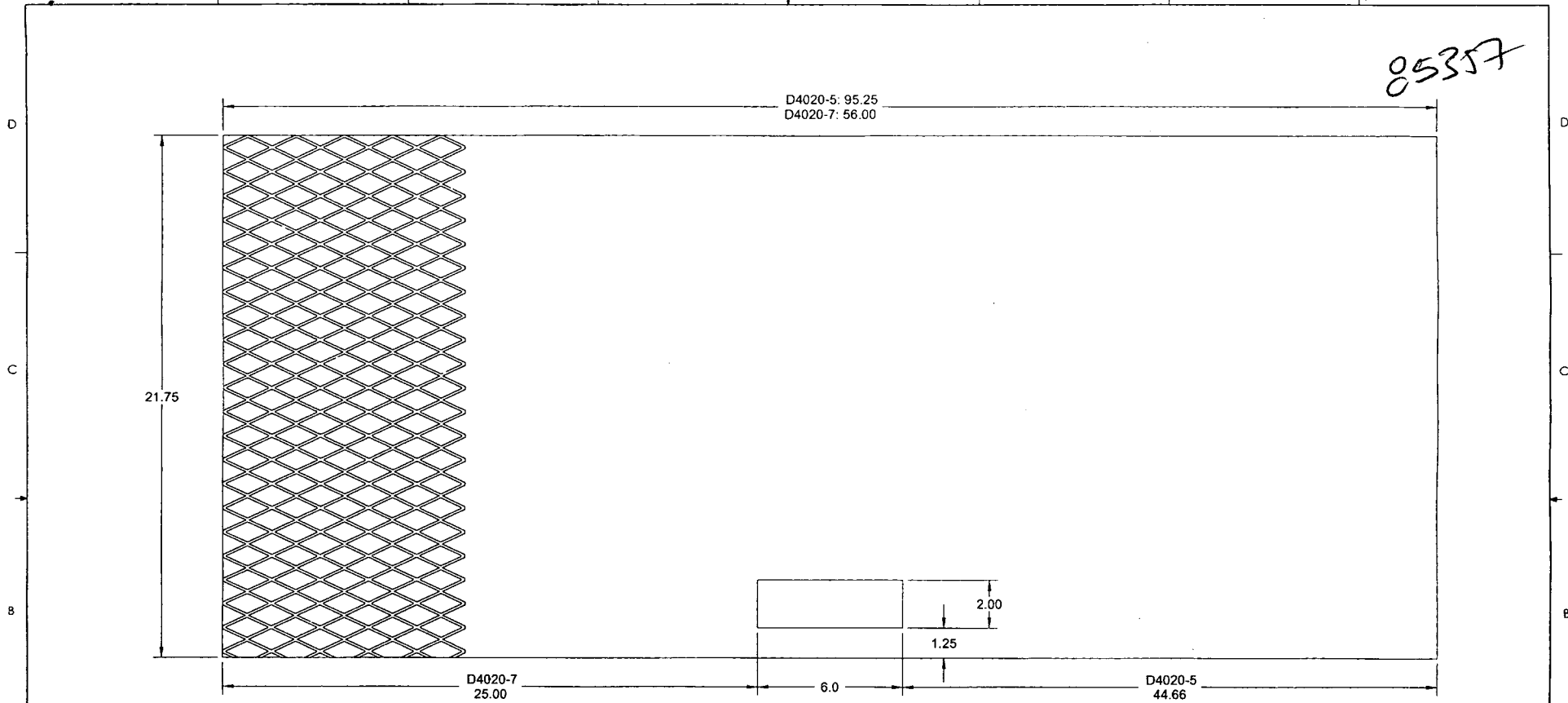
RELEASED  
2010-03-12  
MLJ

NOTES:

- 1) MATERIAL-1: MAKE FROM D4020-1F  
-3: MAKE FROM D4020-3F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE D4020-1F & D4020-3F
- 8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
- 9) PRE-FORMING OF MESH PER SHOP OPTION, THIS VIEW MAY BE USED FOR REF ONLY

A		NEW ISSUE		JPH	10.03.04
REV.		DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	JPH				
CHECKED	g	DRAWING NO.	REV. A		
MFG. APPR.	E	D4020	SHEET 1 OF 4		
APPROVED	MLJ	TITLE	SCALE		
DE APPR.	#	350 BASKET MESH (BASE)			NTS
DATE	10.03.04				
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85357



9) **D4020-5 MESH (350 BASKET LONG, LID)**  
(LOCAL SECTION MESH SHOWN FOR CLARITY)

9) **D4020-7 MESH (350 BASKET SHORT, LID)**  
(LOCAL SECTION MESH SHOWN FOR CLARITY)

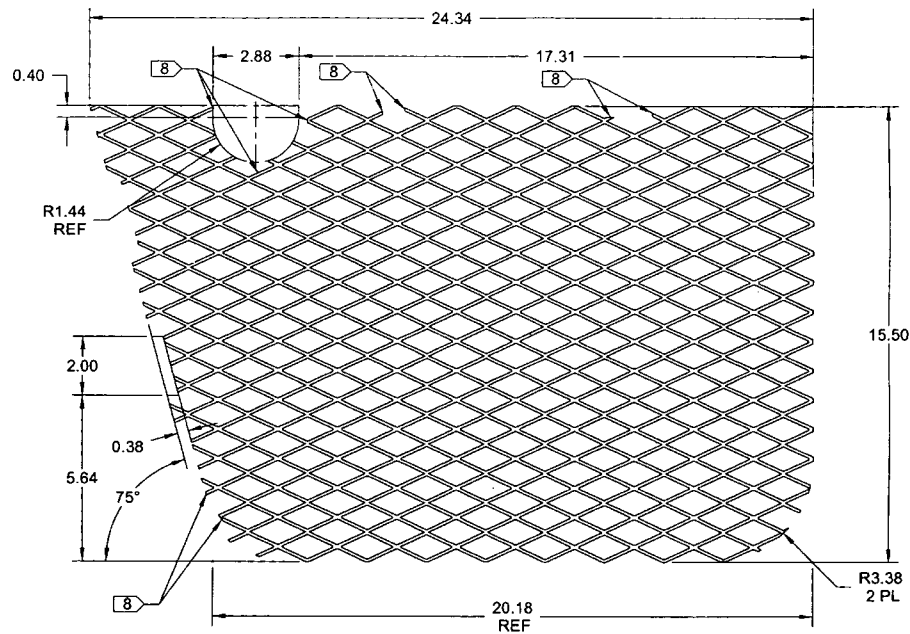
**NOTES:**

- 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F  
REF DART SPEC. M304EX0.75-16F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -5: 0.80 lbs APPROX  
-7: 4.49 lbs APPROX
- 8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
- 9) TOLERANCE ON XX.XX DIMENSIONS  $\pm 0.06$ .

**RELEASED**  
2010-03-12  
JMD

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JZ	DRAWING NO.	REV. A
MFG. APPR.	JZ	D4020	SHEET 2 OF 4
APPROVED	JMD	TITLE	SCALE
DE APPR.	JMD	350 BASKET MESH (BASE)	NTS
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25357



9 D4020-11 END MESH, BASKET

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2010-03-12  
JMD

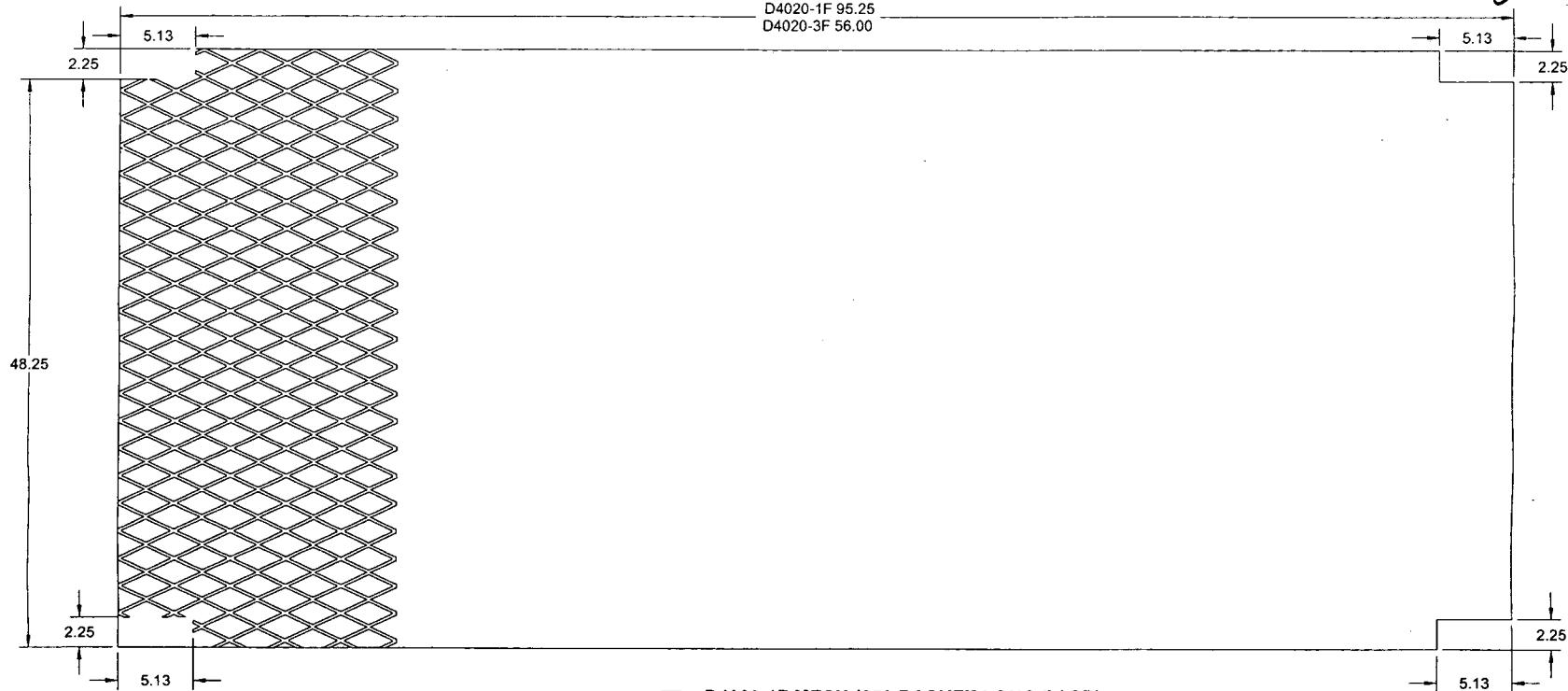
NOTES:

- 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F  
REF DART SPEC. M304EX0.75-16F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.22 lbs
- 8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
- 9) TOLERANCE ON XX.XX DIMENSIONS  $\pm 0.06$ .

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4020	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	350 BASKET MESH (BASE)	NTS
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85317

D4020-1F 95.25  
D4020-3F 56.00



8 D4020-1F MESH (350 BASKET LONG BASE)  
(LOCAL SECTION MESH SHOWN FOR CLARITY)

8 D4020-3F MESH (350 BASKET SHORT, BASE)  
(LOCAL SECTION MESH SHOWN FOR CLARITY)

RELEASED  
2010-03-13

NOTES:

- 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F  
REF DART SPEC. M304EX0.75-16F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1F: 17.33 lbs APPROX  
-3F: 10.16 lbs APPROX
- 8) TOLERANCE ON XX.XX DIMENSIONS  $\pm 0.06$ .

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	9	DRAWING NO.	REV. A
MFG. APPR.	3	D4020	SHEET 4 OF 4
APPROVED	MA	TITLE	SCALE
DE APPR.	#	350 BASKET MESH (BASE)	NTS
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